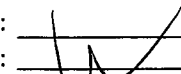
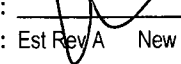


Date: * Monday, 25/08/2008 10:47:16 AM
 User: Linda Lacelle









Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PIN
Job Number	: 41616		
Estimate Number	: 12672		
P.O. Number	:	Part Number	: D31471
This Issue	: 25/08/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3147 REV C
First Issue	: //	Project Number	: N/A
Previous Run	: 33628	Drawing Revision	: C
	Type : MACHINED PARTS	Material	:
Written By	: 	Due Date	: 26/08/2008
Checked & Approved By	: 	Qty:	20
Comment	: Est Rev A New Issue 07-01-26 JLM Est Rev:B Now on Cnc 07-05-02 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M303R0187	303 Round Bar 0.187"
 		
Comment: Qty.: 0.2363 f(s)/Unit Total : 4.7250 f(s) 303 Round Bar 0.187" Batch: <u>11105341</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
 		
Comment: 1-TURN AS PER FOLIO FA691 & DWG D3147 , FOLIO REV: <u>C</u> DWG REV: <u>C</u> 2-DEBURR AS REQUIRED		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
 		
Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA691 Rev: <u>C</u> & Dwg D3147 Rev: <u>C</u> 2-Deburr per dwg D3443		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 25/08/2008 10:47:16 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN

Job Number: 41616

Part Number: D31471

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RD 08/08/25

(22)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 08/08/26

(23)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *69*

8/8/27

(22x)

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/27

Job Completion



U 08/08/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

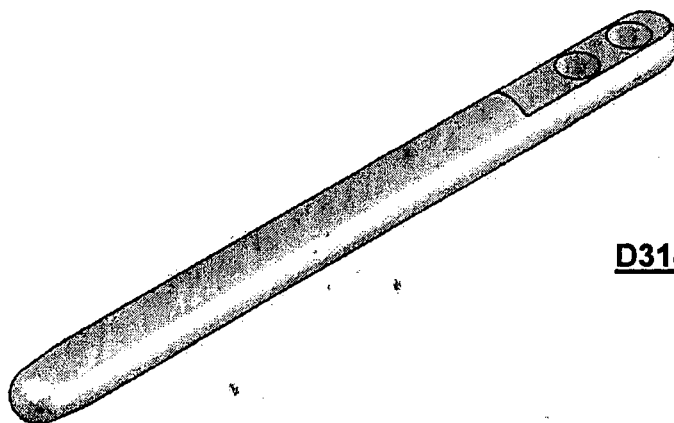
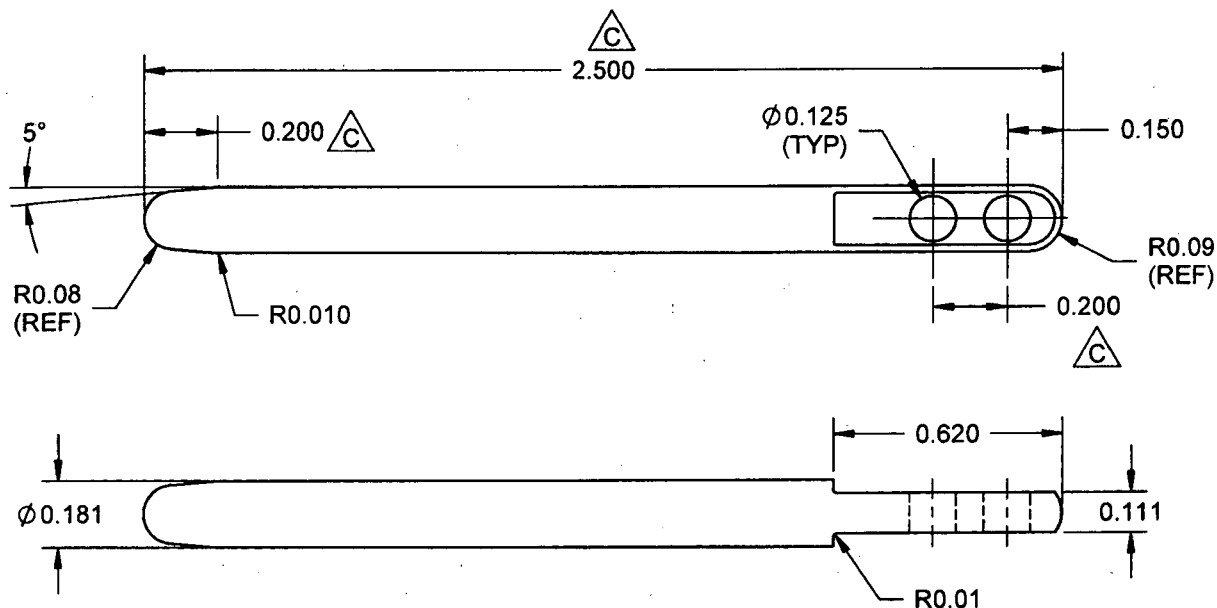
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: .		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3147	REV. C SHEET 1 OF 1
DATE 06.12.04	TITLE PIN SCALE 2:1		
REV	DATE	DESCRIPTION	
A	02.04.23	NEW ISSUE	
B	04.10.18	ADD PART MARKING AND NORMALIZED	
C	06.12.04	ADD SECOND Ø0.125 HOLE; CHANGE MATERIAL; 0.200 TAPER WAS 0.400; REMOVE SUPPLIER AND FINISHING	



D3147-1 PIN

W/041616

RELEASED

07-01-22

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3147-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015 MAX
- 7) REPLACES PREMIER P/N B30-23000-119

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